

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-001601**Date Inspected:** 08-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Dao, Shanghai**Quality Control Contact:** William (Bill) Oak**Quality Control Present:** Yes No**Material transfer:** Yes No N/A**Sampled Items:** Yes No N/A**Stock Transfer:** Yes No N/A**OK to Cut:** Yes No N/A**Rebar Test Witness:** Yes No N/A**Delayed/Cancelled:** Yes No N/A**Other:** Coatings Inspection**Bridge No:** 34-0006**Component:** Sub-Assemblies, OBG 7BE, OBG 6CW, OBG**Bid Item:** 77, 78, 79**Lot No:** B265**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE III coating inspector, Mr. James Lumley arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. The purpose of the coating inspections are to monitor the surface preparation and coating applications for the SAS Bay Bridge project. This QA NACE III coating inspector observed the following:

OBG 7AE

External Base metal surfaces were abrasive blasted to an SSPC SP-10 condition and Interzinc 22 applied. Profile amplitude was 74-84 um, and Chloride values were recorded at 10us/cm. During the nightshift Caltrans QA Paul Dawson performed VT inspection and mapped accordingly. The coating inspection process too 4 subsequent inspections until SSPC SP-10 was achieved.

Sub-Assemblies

Base metal surfaces of approximately 2,300 pieces of varied splice plates and angle iron coded: X37K, X37L, X37G, X37H, X37P, X37J were abrasive blasted to an SSPC SP-10 condition and Interzinc 22 applied. Profile amplitude was 62-80um.

OBG 6CW

ZPMC was observed by Caltrans QA Lumley applying specified undercoats to internal surfaces of this segment during Non-Compliant ambient conditions within the painting workshop. Caltrans QA Lumley then contacted ABF QA Dave Duon to verify ambient conditions within the painting workshop to which ABF Dave Duon responded by sending another ABF QA to ascertain and verify. Caltrans QA Lumley informed ABF Dave Duon that an Incident Report would be generated as a result of the non compliant issue. International Protective Coatings Technical Service Representative Mr. Zili Peng was consulted relative to the aforementioned issue and Mr. Peng stated "reject". ZPMC continued performing repairs to the internal surfaces. Caltrans QA Lumley ascertained that

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approximately 3 hours of work had been done during non-compliant ambient conditions. ZPMC requested an Inspection of the external surfaces later on in the afternoon after the ambient conditions were amenable for painting application, consisting of the testing protocols required of Inorganic zinc undercoat prior to application of the Interfine 979 "Mist" coat. All testing was in compliance with the contract documents and Interfine 979 "Mist" coating was applied.

OBG 6AE

Base metal surfaces of the Cross Beam Bottom Plate beneath the FL-3 Beams and the Segment support areas were abrasive blasted to an SSPC SP-10 condition and Interzinc 22 was applied. Profile amplitude was 74-81um. Work was performed in the Trial Assembly area.

Tower Sub-Assemblies

Base Metal surfaces of 30 L-Splice plates code MP3-300 were washed and de-greased in accordance with SSPC SP-1 in preparation of abrasive blasting.

Note: ZPMC personnel were observed performing repairs to the machine components and piping repairs on the inside of Blast workshop #2. Welding and Torch cutting has been observed within the blasting workshops to perform needed repairs.

Note: All inspections were performed jointly with ABF & ZPMC QA/QC representatives and Caltrans QA Lumley when achievable. International Protective Coatings technical service representative were available for inspections and consultation.

Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang. (858) 699-9549, who represents the Office of Structural Materials for your project.

Inspected By:	Lumley,James	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
